

SPECIFICATION CONTROL DRAWING

PURCHASE MATERIAL: AISI 4340 ROUND BAR
SPECIFICATION: AMS 6484
TOLERANCES: AMS 2251 TABLE 5 (SEE TABLE BELOW)
PART NUMBER: M4340R[D.DDD]-X
DIA. COND.
WHERE "D.DDD" IS THE DIAMETER IN INCHES
AND "X" IS THE CONDITION = "N" (NORMALIZED) OR MINIMUM TENSILE STRENGTH IN KSI
EXAMPLE: M4340R1.000-N = 1" DIA. 4340 ROUND BAR, NORMALIZED
M4340R1.000-166 = 1" DIA. 4340 ROUND BAR, Ftu=166 KSI (ROCKWELL C38, BRINELL 352)

Table 5 - Tolerances, hot finished rounds and squares

Specified Diameter or Thickness Inches		Tolerance Inch Plus	Tolerance Inch Minus	Out-of-Round or Out-of-Square Inch
Up to	0.3125, incl	0.005	0.005	0.008
Over 0.3125 to	0.4375, incl	0.006	0.006	0.009
Over 0.4375 to	0.625, incl	0.007	0.007	0.010
Over 0.625 to	0.875, incl	0.008	0.008	0.012
Over 0.875 to	1.000, incl	0.009	0.009	0.013
Over 1.000 to	1.125, incl	0.010	0.010	0.015
Over 1.125 to	1.250, incl	0.011	0.011	0.016
Over 1.250 to	1.375, incl	0.012	0.012	0.018
Over 1.375 to	1.500, incl	0.014	0.014	0.021
Over 1.500 to	2.000, incl	0.016	0.016	0.023
Over 2.000 to	2.500, incl	0.031	0	0.023
Over 2.500 to	3.500, incl	0.047	0	0.035
Over 3.500 to	4.500, incl	0.063	0	0.046
Over 4.500 to	5.500, incl	0.078	0	0.058
Over 5.500 to	6.500, incl	0.125	0	0.070
Over 6.500 to	8.250, incl	0.156	0	0.085
Over 8.250 to	9.500, incl	0.188	0	0.100
Over 9.500 to	10.000, incl	0.250	0	0.120

OUT-OF-ROUND = MAX O.D. MEASUREMENT- MIN O.D. MEASUREMENT

RELEASED
2021 JAN 12

APPROVED

A	NEW ISSUE	SAD	20.10.29
REV.	DESCRIPTION	BY	DATE
DESIGN	SAD	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	DD	M4340R	SHEET 1 OF 1
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	4340 ROUND BAR	NTS
DATE	20.10.29	COPYRIGHT © 2020 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	